

Date: Tuesday, 15/04/2008 3:33:33 PM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	GHW MOD KIT	
<b>Job Number</b> :	38606	<b>Part Number</b> :	D350615041	
<b>Estimate Number</b> :	11182	<b>Drawing Number</b> :	D350-615	
<b>P.O. Number</b> :		<b>Project Number</b> :	N/A	
<b>This Issue</b> :	15/04/2008	<b>S.O. No.</b> :		
<b>Prsht Rev.</b> :	NC	<b>Drawing Revision</b> :	B	
<b>First Issue</b> :	//	<b>Material</b> :		
<b>Previous Run</b> :	37805	<b>Due Date</b> :	30/04/2008	<b>Qty:</b> 42 Um: Each
<b>Written By</b> :				
<b>Checked &amp; Approved By</b> :	JLD 084.15			
<b>Comment</b> :	Est Rev:K Removed Manufacturing 05-12-05 JLM			

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels (2 GHW Kits per box) as per PPP D350-615-041 CHG003

08/04/21 JLD

08/04/22

2.0	D2282041	T Assembly
-----	----------	------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 42.0000 Each(s)  
 T Assembly

B 38145

SA 08/04/21

(42)

3.0	D2282043	Saddle Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 42.0000 Each(s)  
 Saddle Assembly

30775 B

AS 08/04/16

(42)

4.0	D30153	Locknut
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Comment: Qty.: 3.0000 Each(s)/Unit Total : 126.0000 Each(s)  
 Pick:

Qty Part Number	Description Batch
3 D3015-3	5/16 Locknut

30794

AS 08/04/16 (42)

5.0	D30155	SS Nylock Nut 7/16
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 42.0000 Each(s)  
 Pick:

Qty Part Number	Description Batch
1 D3015-5	7/16 Locknut

37770

AS 08/04/16 (42)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 15/04/2008 3:33:33 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GHW MOD KIT

Job Number: 38606

Part Number: D350615041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

51618015C

SS Bolt 5/16-18 1.5" L



Comment: Qty.: 3.0000 Each(s)/Unit Total : 126.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 5/16-18-015C 5/16 Bolt 1.5 Long

M106869

AS 08/04/16 (x42)

7.0

516WC

SS Flat Washer 5/16



Comment: Qty.: 12.0000 Each(s)/Unit Total : 504.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 5/16WC 5/16 Flat Washer

M106869 x4 M107541 x500

AS 08/04/16 (x42)

8.0

71614050C

SS Bolt 7/16 5" Long



Comment: Qty.: 1.0000 Each(s)/Unit Total : 42.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 7/16-14-050C 7/16 Bolt 5.0 Long

M106861

AS 08/04/16 (x42)

9.0

716WC

SS Flat Washer 7/16



Comment: Qty.: 2.0000 Each(s)/Unit Total : 84.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 7/16wc 7/16 Washer

1 D2282-041(Ref)

"T" Handle Assembly

1 D2282-043 (Ref)

Saddle Assembly

M106162 x25  
38145  
36775B

\* Same only 24 in camp. Batch had 24 in camp. we'd take 1 in camp that from that Batch.

AS 08/04/16 (x42)

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D2282-041 with D2282-043 as per Dwg D350-615 Only engage one instead on three 5/16-18-015C bolts

AS 08/04/21

AS 08/04/21

(42)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

AS 08/04/21 (x42) counts

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 15/04/2008 3:33:34 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GHW MOD KIT

Job Number: 38606

Part Number: D350615041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

8/4/22 C (X)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-615-041

Location: \_\_\_\_\_

PPP Rev: \_\_\_\_\_

E

8/4/22 scf (X)

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/22 J

Job Completion



W08-04-22

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**4. WEIGHT AND BALANCE**

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D076-612-011 Cargo Mirror, 6"	1.8 lb 0.82 kg	±46.5 in ±1.18 m	±83.7 in-lb ±0.97 m-kG	99.1 in 2.52 m	178.4 in-lb 2.07 m-kG
D076-612-015 Cargo Mirror, 8"	2.3 lb 1.04 kg	±46.5 in ±1.18 m	±107.0 in-lb ±1.23 m-kG	99.1 in 2.52 m	227.9 in-lb 2.62 m-kG

**5. PARTS LIST**

Qty -011	Qty -015	Part Number	Description
X		D076-612-011	CARGO MIRROR, 6"
	X	D076-612-015	CARGO MIRROR, 8"
1		D2011-101	Mirror (6")
	1	D2011-103	Mirror (8")
1		*D3014-1	Locknut
	1	*D3015-3	Locknut
1		*AN960JD416L	Washer
	1	*AN960JD516	Washer
3	3	D2012-117	Clevis
1	1	D2261	Arm Assembly
1	1	D2262	Arm Assembly
4	2	D2263-1	Clamp
	2	D2263-3	Clamp
3	3	D2264	Cushion
3	3	D2271	Bracket
3	3	AN3-11A	Bolt
3	3	AN4-5A	Bolt
9	9	AN960JD10	Washer
10	10	AN960JD416	Washer
6	6	MS21042L3	Nut (or MS21042-3)
3	3	MS21042L4	Nut (or MS21042-4)
3	3	MS27039-1-14	Screw
9	9	NAS1738B-4-2	Blind Rivet

\*INCLUDED AS PART OF D2011-101/-103 MIRROR ASSEMBLY

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 38606

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Revision: **A**  
Date: 02.06.26

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries





DESIGN <i>BW</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>DMY</i>	APPROVED <i>BW</i>	DRAWING NO. D350-615	REV. 8 SHEET 1 OF 2
DATE 97.10.21		TITLE GROUND HANDLING WHEEL MOD.	SCALE NTS
A	95.03.23	NEW ISSUE	
B	97.10.21	CHANGE NUMBERING SCHEME	

-041	Part No.	Description
X	D350-615-041	Ground Handling Wheel Mod.
1	D2282-041	"T" ASSEMBLY
1	D2282-043	SADDLE ASSEMBLY
3	5/16-18-015C	5/16 BOLT 1.5 LONG
3	5/16-18NC	5/16 LOCKNUT (D3015-3)
12	5/16WC	5/16 WASHER
1	7/16-14-050C	7/16 BOLT 5.0 LONG
1	7/16-14NC	7/16 LOCKNUT (D3015-5)
2	7/16WC	7/16 WASHER

THESE INSTRUCTIONS ARE TO BE USED IN CONJUNCTION WITH  
THE AIRCRAFT MAINTENANCE AND OVERHAUL INSTRUCTION MANUAL  
AC43.13.1A & 2A ACCEPTABLE METHODS, TECHNIQUES, AND PRACTICES

#### INSTALLATION:

1. Remove existing ground handling wheel pump saddle.
2. Replace saddle with D350-615-041.
3. Torque 5/16 bolts to bottom, then back-off half turn to allow easy rotation without excessive play.



DESIGN EWS	DRAWN BY KE	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	REV. B
CHECKED JMW	APPROVED EWS	DRAWING NO. D350-615	SHEET 2 OF 2
DATE 97.10.21	TITLE GROUND HANDLING WHEEL MOD.	SCALE NTS	



